

20/05 12test

Dart Aerospace Ltd.

Date: Thursday, 01/05/2008 4:16:32 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 38968	
Estimate Number : 10420	
P.O. Number :	Part Number : D3303043
This Issue : 01/05/2008 S.O. No. :	Drawing Number : D3303 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 29944	Material :
Written By :	Due Date : 16/05/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 08502</u>	
Comment : Est: A 04.09.07 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33031	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLATE

Pick:

Qty	Part Number	Description	Batch
1	D3303-1	Plate	B 41219 ②

B 41680 17

09/04/16 ②

2.0	D33033	Bracket
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3303-3	Bracket	B 41681

B 41681

09/04/16 ②

3.0	MS20426AD33	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
8	MS20426AD3-3	Rivet	M 7681

M 7681

09/04/16

4.0	MS20470AD44	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 16.0000 Each(s)/Unit Total: 128.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
			M 11193

M 11193

09/04/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:32 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 38968

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 MS20470AD4-4 Rivet

5.0

MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nutplate

Pick:

Qty Part Number

Description

Batch

4 MS21075L3

Nut Plate

M109341(44)

M111119(36)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

****MASK THREADS PRIOR TO PAINT****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30
320°
9:00

M109648.

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

185




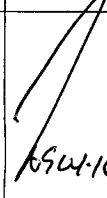
9/4/20

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-043 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/16
 QA: N/C Closed: _____ Date: _____

NCR: 38968		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/16	# 6.0	One (Qty 1) D3033-1 Found with Dent in middle of Part, appears to be after plating. R.G. curlessness in stock		dent is 0.010 deep by 0.100 long & wide - scrap & destroy qty 1		8 09/04/16		

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:32 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 38968

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

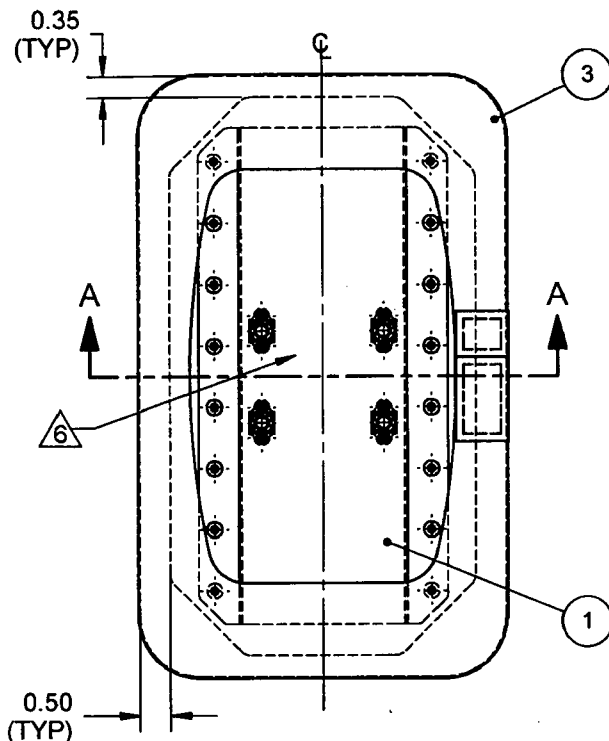
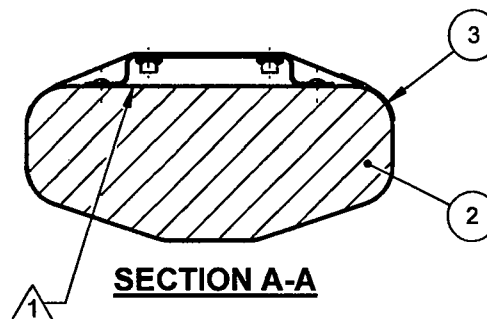
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED***dc 09.19***SECTION A-A****D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *38768*

NOTES:

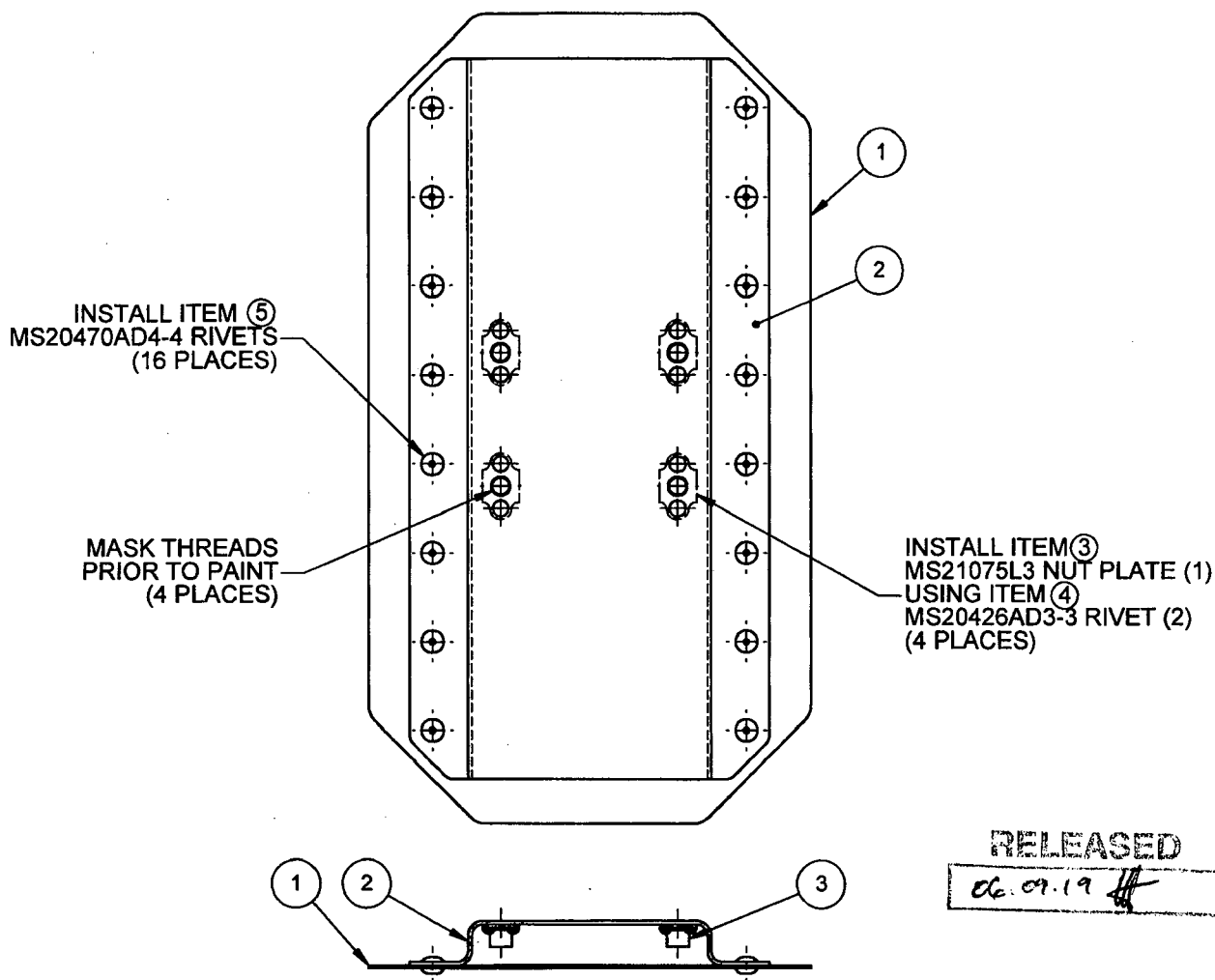
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED
06.09.19 *PH*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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WORK ORDER
NO. *38962*

NOTES:

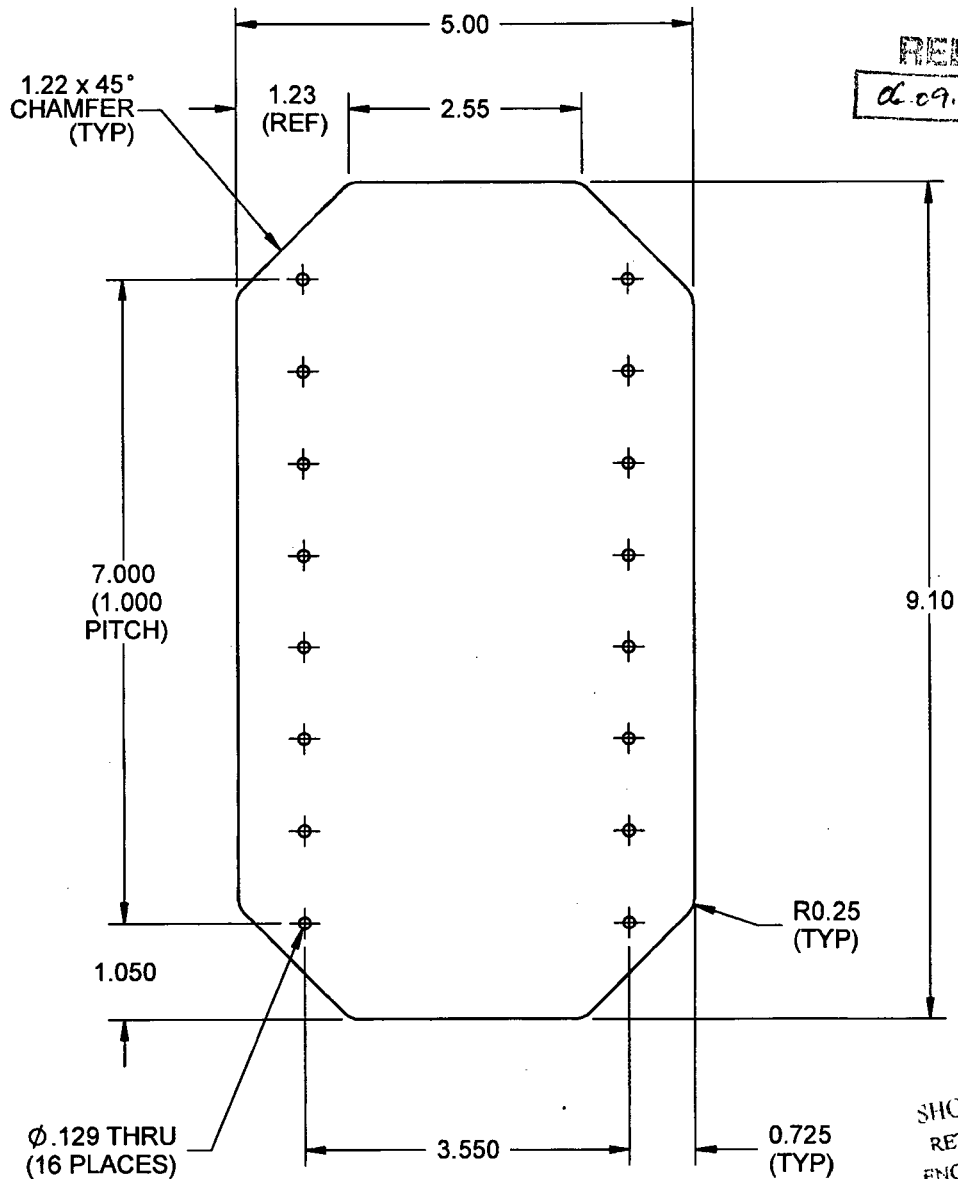
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

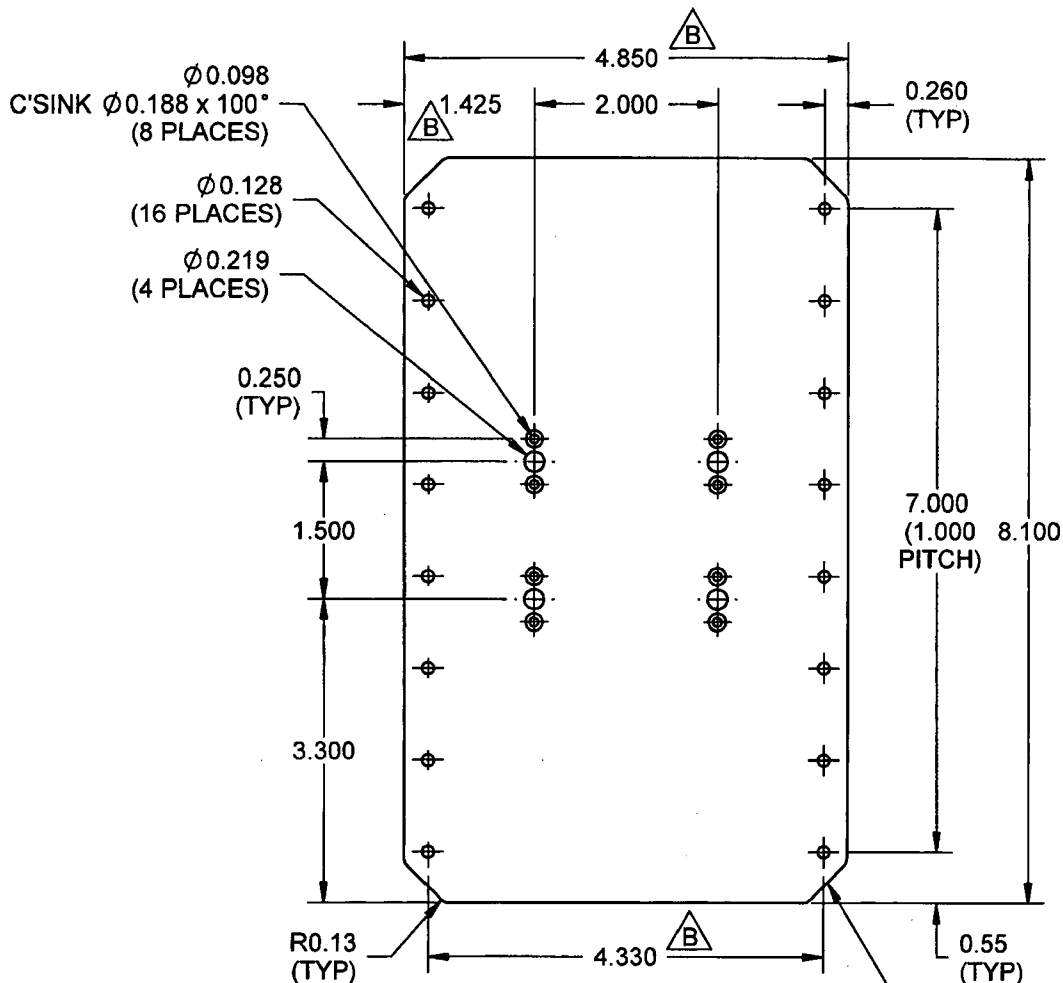
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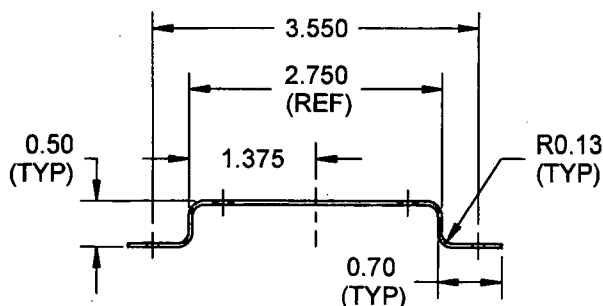
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D3303-3F BRACKET FLAT PATTERN

RELEASED
06.09.19

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D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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